

Work Order ID 68830-2

Thursday, April 21, 2011 11:33:31 AM

Page 1

Item ID: D2332-041

Revision ID:

Item Name: Lid Prop Assembly 6.69" long

Start Date: 4/21/2011 Start Qty: 10.00

Required Date: 4/26/2011 Req'd Qty: 10.00

Reference:

Approvals: Process Plan: CY

QC:

Date: 11/04/21 Tooling:

Date: SPC (Y/N):

Cust Item ID:

Customer:

Setup Start

Stop

Run Start

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID Tool # Plan Code Accept Qty Reject Qty Reject Number Insp. Stamp

Draw Nbr

Revision Nbr

D2332

Rev C1

0.00

0.00

Memo

1- Cut D2332-7 and D2332-5 to length as per dwg D2332.

2- Cut D2332-11 using 1/2" S.S tubing 7.735" long.

3- Deburr.

0.00

0.00

Memo

Punch and form D2332-11 to length as per dwg D2332 using DT8012 (need 2 per ass'y)

110



Brake NC

Brake NC

5X

m.p 11/05/17

m.p 11/05/17 5X

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 68830

Thursday, April 21, 2011 11:33:32 AM



Page 2

Item ID: D2332-041

Accept



Setup Start



Revision ID:

Stop



Item Name: Lid Prop Assembly 6.69" long

Start Date: 4/21/2011 Start Qty: 10.00



Cust Item ID:

Required Date: 4/26/2011 Req'd Qty: 10.00



Customer:

Reference:

Run Start



Approvals:

Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID Tool # Plan Code Accept Qty Reject Qty Reject Number Insp. Stamp

120

0.00



Small Fab

Memo

0.00

1- Drill hole in D2332-11 as per dwg D2332 using drill jig DT8459
(drill one per ass'y)

2- Ensure no foreign objects inside tube

3- Deburr

=> m-k 11/05/17

(SX)

130

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

SB 11/05/18

140

0.00



Large Fab

Memo

0.00

Weld D2332-11 and D2332-5 as per dwg (weld 1 per ass'y)
*****ensure nothing is inside of tube before welding*****

S.S Rod batch: 1114509

11-5-18 (XS)

W/O:		WORK ORDER CHANGES						
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Work Order ID 68830

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Page 3

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Setup Start



Revision ID:

Stop



Item Name: Lid Prop Assembly 6.69" long

Start Date: 4/21/2011 Start Qty: 10.00



Cust Item ID:

Required Date: 4/26/2011 Req'd Qty: 10.00

Customer:

Reference:

Run Start



Approvals: Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID Tool # Plan Code Accept Qty Reject Qty Reject Number Insp. Stamp

150

QC9- Inspect visual per QSI004- Fusion Welds

0.00



QC

Memo

0.00

Quality Control

Cpl 1105.19

160

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

5/10/11

(+5)

170

0.00



Small Fab

Memo

0.00

Small Fab

1- Tumble

2- Assemble as per dwg D2332

11-5-24

(5)

5/11/11/24 (5)

W/O:		WORK ORDER CHANGES						
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Thursday, April 21, 2011 11:33:32 AM

Page 4

Item ID: D2332-041

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Setup Start



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Customer:

Reference:

Run Start



Approvals: Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

180

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

190

Identify as per dwg & Stock Location: *S12*

0.00



Packaging

Memo

0.00

Packaging

200

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

8/11/12/24

(X)

11/5/24 J/S

11/5/20 J
mf
11-05-25

W/O:		WORK ORDER CHANGES						
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NOTE: Date & initial all entries

Picklist Print

Thursday, April 21, 2011 11:33:27 AM

Page 1

Work Order ID: 68830

Parent Item: D2332-041

Parent Item Name: Lid Prop Assembly 6.69" long



Start Date: 4/21/2011

Required Date: 4/26/2011

Start Qty: 10.00

Required Qty: 10.00

Comments:

IPP: B 02.08.12 Re-format; Incorporated D2332-13/-11/-7/-5 KJ/RF
IPP Rev:C 08-06-02 add comment DD verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

M304R.250

Purchased

No

100

f

12.7800

0.1

1.052632



304 SS Round bar .250

Location

Loc Qty

Loc Code

MAT028

12.78

114482 ✓

12.78

100

f

19.6600

0.43

4.526316

M304TR1.000W.049

Purchased

No



304 RD Tube 1.00 x .049W

Location

Loc Qty

Loc Code

MAT018

19.66

108756 ✓

7

111457

12.66

110

f

11.7907

1.25

13.15782

M304TR0.500W.035

Purchased

No



304 RD Tube .500 x .035W

Location

Loc Qty

Loc Code

MAT017

11.79068

115535

2.33

7x 115990 ✓

5.29

4x 116720 ✓ 251

4.17068

9x 117598 ✓ => 11.8421

9.211

5.2632

~~13.15782~~

m-l 11/05/17



m-l 11/04/29

1.052632

m-l 11/04/28

4.526316

W/O:		WORK ORDER CHANGES						
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Picklist Print

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Parent Item: D2332-041

Parent Item Name: Lid Prop Assembly 6.69" long

Start Date: 4/21/2011

Required Date: 4/26/2011

Start Qty: 10.00

Required Qty: 10.00

AN4-4A

Purchased

No

170

Each

122.0000

1

10



Bolt

Location

Loc Qty

Loc Code

FP-B

48

114615

48

ST356

74

114615

74



EP 11/05/24

*

AN960JD416L

NAS1149D0416J

Purchased

No

170

Each

5.0000

3

30



Washer

42 M 114884

Location

Loc Qty

Loc Code

FP-B

5

110153

5

170

Each

5,333.000

1

10

MS21042L4

Purchased

No



Nut

Location

Loc Qty

Loc Code

ST300

5333

116188

333

116823

2000

117441

3000



EP 11/05/24

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

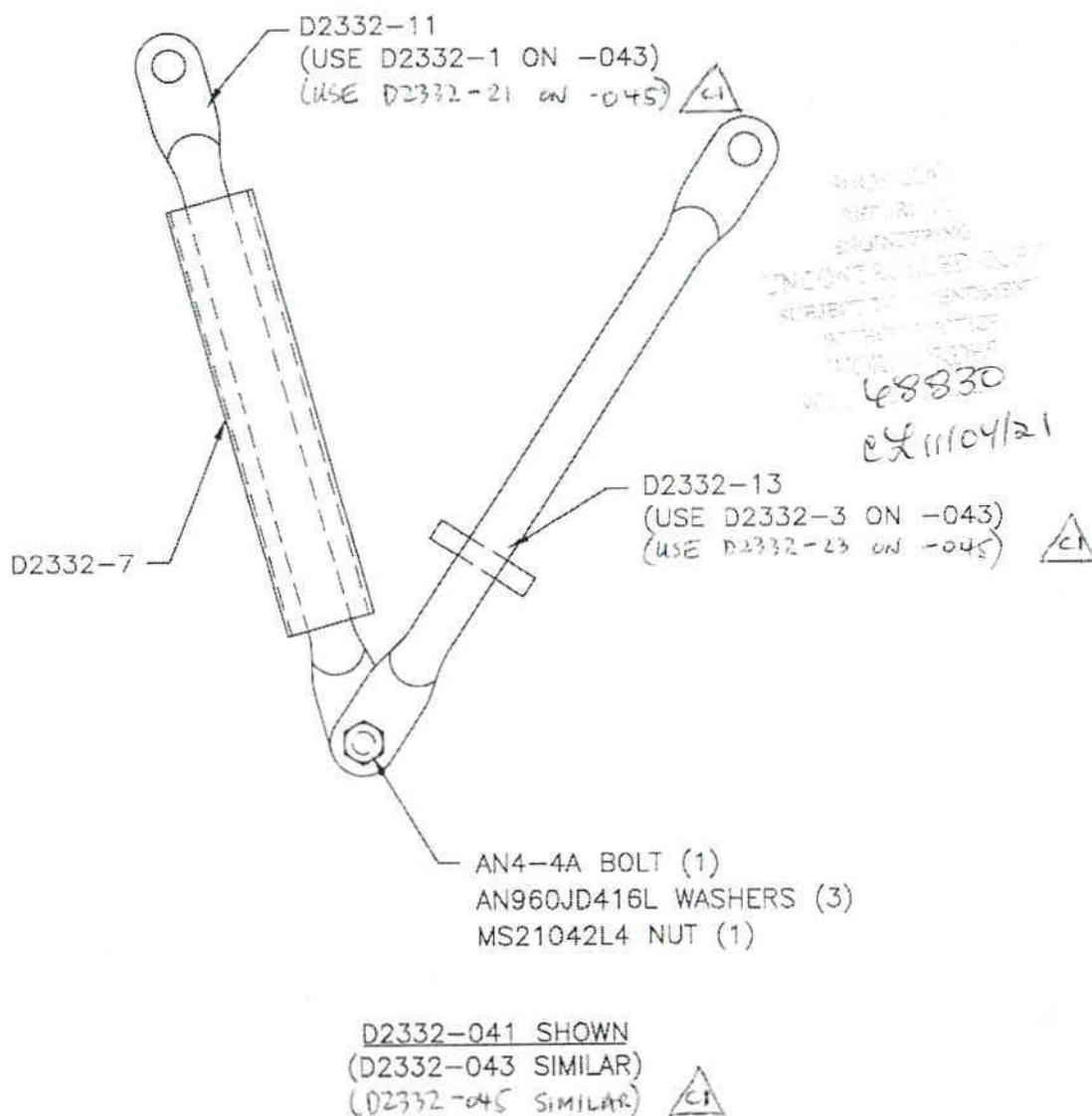
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO. D2332	REV. C SHEET 1 OF 2
DATE 03.07.03	TITLE LOD PROP ASSEMBLY	SCALE NTS	
A	94.12.16	NEW ISSUE	
B	97.09.30	CHANGE 416 WASHERS TO 416L	
C	03.07.03	MAKE -041 PROP 6.69" LONG (STD) MAKE -043 PROP 8.00" LONG (OPT.)	
C1	03.08.06	ADD -045 PROP (7.25" LONG)	

RELEASED
03.07.04



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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

DART



DART AEROSPACE LTD
HAMKESBURY, ONTARIO, CANADA

REV. C

SHEET 2 OF 2

SCALE

1:2

TITLE
LID PROP ASSEMBLY

DRAWING NO.
D2332

DATE
03.07.03

CHECKED
[Signature]

APPROVED
[Signature]

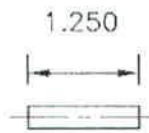
DESIGN
[Signature]

DESIGNED BY
[Signature]

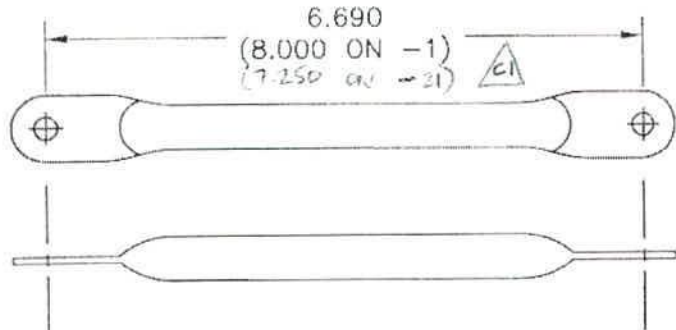
C	03.07.03	MATE - 0.25 PROP 6.64" LONG (END)
C1	03.08.06	MATE - 0.43 PROP 8.00" LONG (CUT)
		ADD - 0.45 PROP (7.25" LONG)



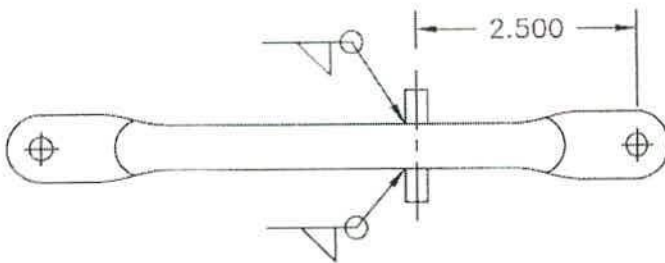
D2332-7 LOCKING COLLAR



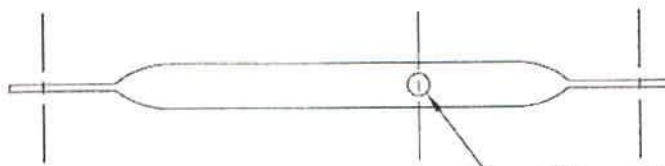
D2332-5 STOP PIN



D2332-11 PROP
(D2332-1 SIMILAR)



D2332-13
M/F D2332-11 & D2332-5
(D2332-3 SIMILAR - M/F D2332-1 & D2332-5)
(D2332-23 SIMILAR - M/F D2332-21 & D2332-5)



DRILL 1/4 HOLE FOR D2332-5

NOTES:

1. MATERIAL: 0.5 OD x 0.035 WALL SS TUBE (D2332-1/-11) M304TR0.500W.035
0.25 OD SS ROD 1.25 LONG (D2332-5) M303R0.250
1.0 OD x 0.049 WALL SS TUBE (D2332-7) M304TR1.000W.049
2. TUBE ENDS ARE CENTER-CENTER FOR D2332-1/-3 & D2332-11/-13

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